

Work Order ID 77458

December-07-11 2:55:25 PM

77458

Page 1

Item ID: D3281-3L02

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Floor Protector, Aft LH (Black)

Stop

NS2

Start Date: 07/12/2011 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 21/12/2011 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/07 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--	----------------------------------	------------------------------	----------------	---------------	----------------------	-----------------------	-----------------------	--------------------------	------------------------

Draw Nbr	Revision Nbr
D3281	Rev F
DSI 9504	A

100 0.00

100 HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

x4 DL
11/12/07

Thermoforming Machine

Cut Blanks

105

105 Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 340°F

Time IN: 4:00 pm 11/12/07

Time OUT: 4:00 am 11/13/07

x4 DL
11/13/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform	THERMOFORMING MACHINE Memo	0.00			x4				SL
Thermoforming Machine	Thermoform as per Dwg. D3281and Folio FTA 009 Dwg. Rev. <u>F</u> Folio Rev. <u>D</u>								11/12/07
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00			x4				SL 11/12/07
130 *130* Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00			x4				SL 11/12/07

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Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Quality Control

x4

Dh

11/12/14

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Quality Control

5/11/14

(X)

160

Packaging

0.00

160

Packaging

Memo

0.00

(X) SP 11-12-14.

PPP-111B1 SP.

W/O:		WORK ORDER CHANGES							
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Work Center ID**

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Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

170

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/12/2011

11-12-10
(H)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

December-07-11 2:55:29 PM

Work Order ID: 77458

77458
D3281-31 02

Parent Item: D3281-3L02

Parent Item Name: Floor Protector, Aft LH (Black)

Start Date: 07/12/2011

Required Date: 21/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A04.07.01New issueKJ/JLM

IPP Rev B 07.08.07 Thermoform in house DL

IPP Rev. C

Add Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased	No				sf	581.2996		17.332			**

MI FXS 093-F6006-02

GE PLASTICS LEXAN SHEET

Location	Loc Qty	Loc Code
therm	581.29958	
106751	105.89	
110877	475.40958	

11/12/08

17.332 sq ft

W/O:		WORK ORDER CHANGES					
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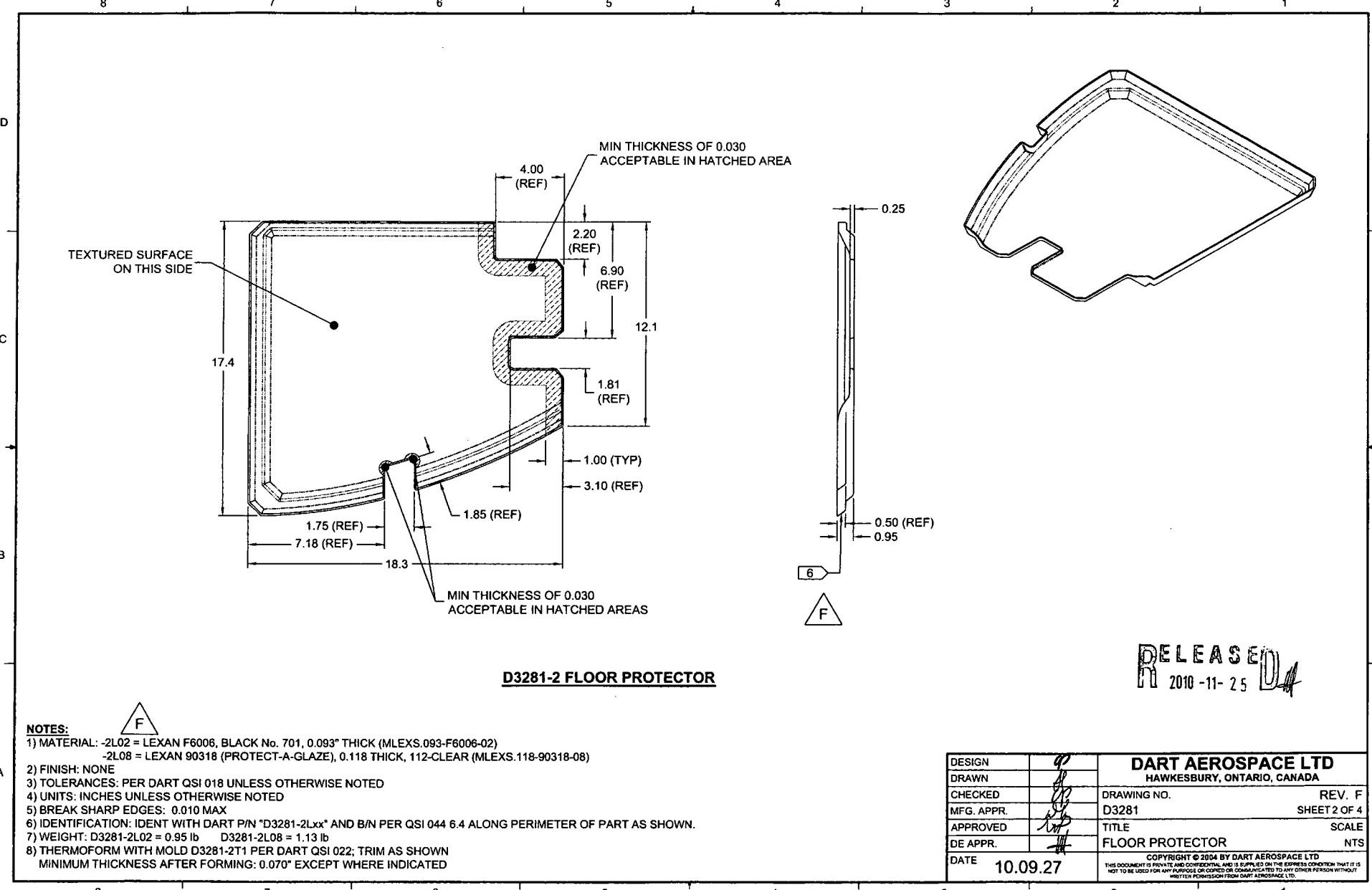
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77450

RELEASED
2010-11-25

W/O:		WORK ORDER CHANGES					
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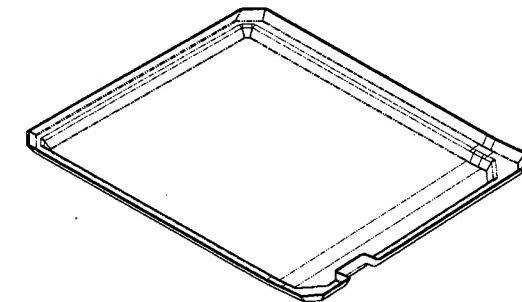
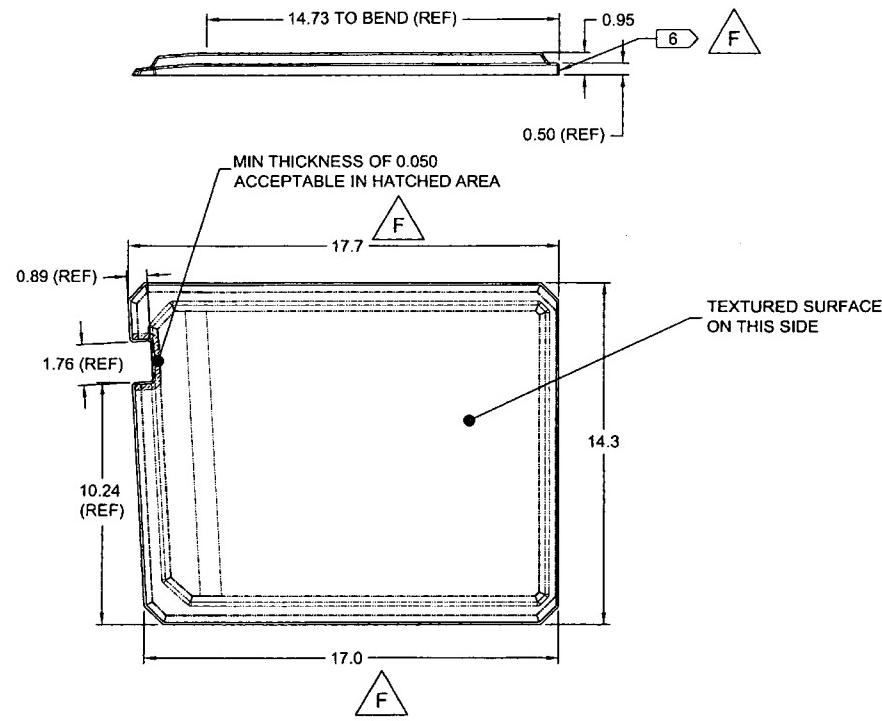
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27450

8 7 6 5 4 3 2 1

D



B

A

**NOTES:**

- 1) MATERIAL: -3L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-3L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-3Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-3L02 = 0.87 lb D3281-3L08 = 1.05 lb
- 8) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

8 7 6 5 4 3 2 1

RELEASE
2010-11-25

DESIGN	9P	DART AEROSPACE LTD	
DRAWN	8	HAWKESBURY, ONTARIO, CANADA	
CHECKED	IP	DRAWING NO.	REV. F
MFG. APPR.	SL	D3281	SHEET 3 OF 4
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	FLOOR PROTECTOR	NTS
DATE	10.09.27	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED OR PROVIDED TO OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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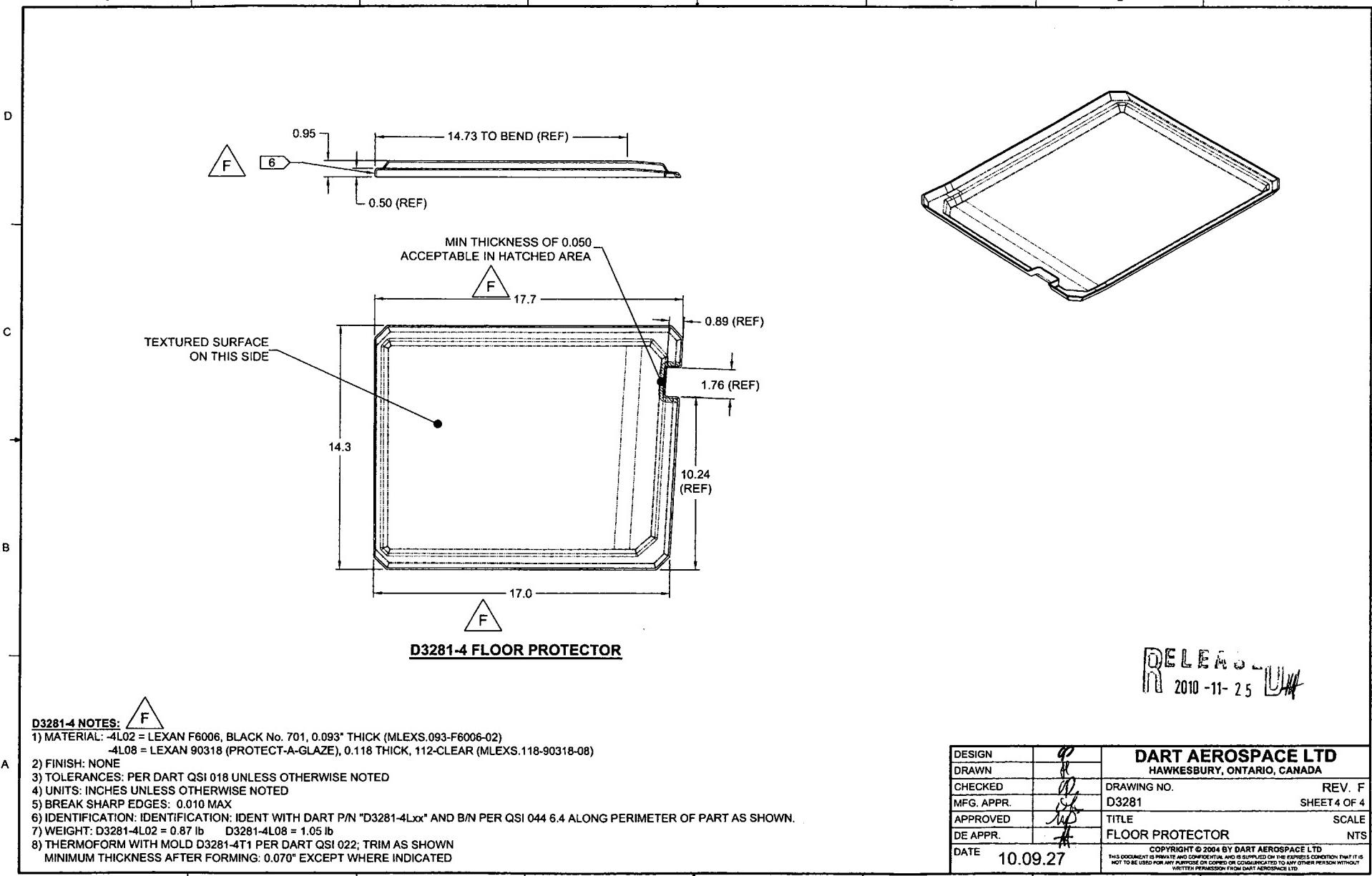
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27458

8 1 7 1 6 1 5 1 4 1 3 1 2 1 1



8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D044-719 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D044-719 REV. 0
REF TCCA STC: SH04-40
REF FAA STC: SR02051NY
REF EASA STC: EASA.I.M.R.S.01075

PURPOSE:

To add the D044-719-011L08 Clear Cabin Floor Protectors. The -011L08 kit is similar to the existing -011 kit, however the plastic is transparent instead of solid black. The existing D044-719-011 kit will be re-identified as D044-719-011L02.

CHANGE:

The D044-719-011L08 Cabin Floor Protectors kit consists of four transparent plastic trays that are placed on the cabin floor to protect the carpets from damage. The -011L08 kit should be installed per the -011 kit of Installation Instructions IIN-D044-719 and maintained per Instructions for Continued Airworthiness ICA-D044-719. The parts list and weight & balance for the -011L08 kit is given below.

PARTS LIST

QTY -011L02	QTY -011L08	Part Number	Description
X		D044-719-011L02	Cabin Floor Protectors (Black)
	X	D044-719-011L08	Cabin Floor Protectors (Clear)
1		D3281-1L02	Floor Protector, Fwd LH, Black
	1	D3281-1L08	Floor Protector, Fwd LH, Clear
1		D3281-2L02	Floor Protector, Fwd RH, Black
	1	D3281-2L08	Floor Protector, Fwd RH, Clear
1		D3281-3L02	Floor Protector, Aft LH, Black
	1	D3281-3L08	Floor Protector, Aft LH, Clear
1		D3281-4L02	Floor Protector, Aft RH, Black
	1	D3281-4L08	Floor Protector, Aft RH, Clear
8	8	D2854-1-100	Looped Velcro Strip
8	8	D2854-3-100	Hooked Velcro Strip

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D044-719-011L02 Cabin Floor Protectors	3.9 lb 1.8 kg	0 in 0 m	0 in-lb 0 m-kg	50 in 1.27 m	195 in-lb 2.3 m-kg
D044-719-011L08 Cabin Floor Protectors	4.4 lb 2.0 kg	0 in 0 m	0 in-lb 0 m-kg	50 in 1.27 m	220 in-lb 2.5 m-kg

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	10.02.24
CERT. NO.:	SH04-40
ISSUE NO.:	1

A	NEW ISSUE		CP	10.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>gp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A	
DRAWN	<i>gp</i>		DSI 9504	
CHECKED	<i>jl</i>	DRAWING NO.		
MFG. APPR.	<i>N/A</i>	REV. A		
APPROVED	<i>jl</i>	TITLE	SCALE	
DE APPR.	<i>jl</i>	FLOOR PROTECTOR KIT, CLEAR	NTS	
DATE	10.02.24	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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DART AEROSPACE LTD	Work Order:	77458
Description: Floor Protector, Aft LH	Part Number:	D3281-3
Inspection Dwg: D3281 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by

1

Date:

11/12/c7

TRIMMING SECTION

Measured by:

19

Date:

11/12/14

Audited by:

2

Date:

412/16

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	
D	10.09.01	Dimensions updated per Dwg Rev E	KJ	
E	11.06.21	Dwg Rev updated	KJ	10/21